EXHIBIT K

IF FOUND RETURN TO

USEPA
National Enforcement Investigations Center (NEIC)
Denver Federal Center, P.O. Box 25227
Denver, CO 80225

04/14/09

Project Number: VP0842-01

Logbook Recipient Signature: Martha Vance

Project Name: Tonawanda Coke Corp.

Location: Tonawanda, New York

Last Logbook Entry on Page 65 **of 100 Pages** MAV **(Initials)**

Entries also on: 80-93
pages 96-97

04/MN/04/09

Opening Conference

Mark Kamholz – Manager, Env. Control

NETC – 2 people
EPA Region 2 – 3 people
NYSDEC – 4 people

Michael Trembelwitz

Credentials were presented to Mark Kamholz

Tonawanda Coke will collect co-located samples for wastewater samples

OVA – 128 for fugitive leak monitoring, monitoring by Tonawanda Coke

Guardian – Visible Emissions for method 303
5 consecutive charges
4 hrs. per day

Production is slow
92 hr. coke time
1 push & charge every 45 minutes

Began slowing up in Oct.
At 92 hr. coke time last ~2 months

30% drop of ce previous level

At 55-60% of capacity

Facility Overview - Mark

1917 - original construction
Semet-Solvay
Allied Chemical - 1920's purchased
#1 Battery shut down in 1972
In 1977
Jan. 1978 - become Tonawanda Coke
#2 Battery - 60 oven, 4 m ; Wilputte coke oven battery

Coke produced varies based on market - 230,000 tons/yr

merchant coke plant - slows when market slows

For 2009, if conditions remain poor, 1/3 less than 230,000 tons/yr

280,000 tons coal for 230,000 tons coke

~80% yield for foundry coke

~70% yield for furnace coke

Use metallurgical coal to make coke.

High, low, med. vols (volatile) coal

Primarily West Virginia coal

Coal by rail to transfer facility south of Buffalo -
Then coal trucked to facility

Cleopatra to have Norfolk Southern drop in Lackawanna terminal & truck thru to have coal delivered into plant

Occasionally do receive coal via train directly to plant

Coal Blending

7 bins in breaking bldg.

Mixing table
Based on bulk density

Pushers side collection main
Divided in 2

Use all 60 ovens still, just lengthen time & lower temp in ovens

Waste heat stack - off furnaces

#8 Stack for #7 boiler
#9 Stack - abandoned

L.O. Still down since Nov. 2008

Using nat. gas as supplemental fuel

Leave light oil in gas & get higher BTUs

Economics not good to sell light oil

Gas being used to fire furnaces

Coke oven gas to ovens & boilers

L.O. in gaseous phase when burning in boilers.

Also have back-up boilers with small stack - pkg. boilers

35,000 - 50,000 lbs/hr. of steam for #7 boiler
1947 vintage - #7 boiler
option of burning coal removed in 1980

Flare on coke oven battery, emergency flare
Pilot light on all the time
No steam assist

Coke oven gas would go to flare if not routed to plant - if exhausters not working

Always in a coke oven gas deficient

Pressure relief valves - no

Big-products plant flow diagram

No gas compressed anymore

BH Decanter = tar decanter

2-300 gpm cooling water

Stand pipe to collector main from oven

Condensing volatiles out - cooling water spray nozzles

Primary & Secondary coolers - water cooled

85°C into primary cooler

~30°C after secondary cooler (gas)

Tar on bottom of tar decanter, heavier than water

BH Liquor

2 concrete lagoons, in series

Tar dehydrator & tar storage used interchangeably

2 - horizontal tanks

16,000 gal tanks

Really 2 storage tanks

Sell tar as crude tar.

Look at moisture & quinoline (q.i.) index & ash

1,500,000 gallons tar sold per year

Liquor from decanter to surge tank

Water from moisture in coal & fresh water make-up to NH_3 removal

Steam traps also go to surge tank - closed vessel, no vent

Weak liquor storage tank - used to have 3, now only 1

AC Still - Ammonia Concentrate still

Liquor pumped from AC still to Eq. Tank

AC Still uses live steam

Overheads from AC Still go to atmosphere

5 to 7000 lbs per hour of steam to AC Still

37 gpm - liquor feed to AC still

Eq. tank - open top tank

POTW - cyanide, ammonia, pH, naphthalene, BTX semi-annual

Flow to POTW (total) - Approx 100,000 gpd

Coolers - vertical cylinders

Primary - 80 ft. tall

Secondary - 40 ft. tall

3 exhausters, but only one operates at a time

3 in parallel, maybe able to operate in series

Multi stage, centrifugal fan

Tar precipitator - final clean-up on gas, any remaining tar entrained in gas.

Is an ESP

NH_3 removal, direct wash countercurrent water wash on gas

Water used in NH_3 removal is softened water

Light oil removal out of service since Nov. 20, 2008
Taken out of service because short on coke oven gas and energy (steam) so save light oil in gas & use in boiler & oven

Light oil is typically 50% benzene

Wash oil ⇒ high boiling paraffinic oil
Purchased by Tonawanda Coke

Wash oil - MSDS

Light oil removal - is a tower

Gas stream hit with wash oil, gas goes (absorbed) into wash oil
Light oil & wash oil separated in wash oil still, wash oil to decanter as last unit to remove remaining light oil, wash oil recirculated back
Light oil from wash oil still & decanter to light oil storage

Wash oil still - use steam in bottom

2 condensers off wash oil still

Water mixed with wash oil to secondary wash oil decanter to weak liquor storage tank

Light oil - primarily benzene, toluene, xylene & naphthalene

~ 920,000 gallons/yr
when recovering light oil & making 230,000 tons of coke

Tar production & light oil production directly related to amount of coke produced

30,000 gal - horiz. tank
vented to atm. previously

Have just installed a control system which is a vacuum line routed to suction side of exhauster

Also truck loading splash fill routed to same vacuum system
2-3 trucks per week typical for light oil

Add oil to coal blend
used motor oil
Removed coal tar also added to coal
} small percentages

Emissions control

Decanter
Tar Storage Tanks
Collecting Tank
} routed to suction side of exhausters therefore under vacuum

Gauges on above vessels, individual locations

No other controls

Material balance on AC Still

Looking into recovering emissions off AC Still
Ammonia - 300 tons/yr off AC still

Battery under slight pressure

Plant Tour

~ 170 employees
24 hr, 7 day/week operation
3 Shifts

Coke oven gas - red pipes

2 exhausters #2 & #3
#2 is running

Primary & Secondary Coolers
- Inert ~~w~~ atmosphere with liquor

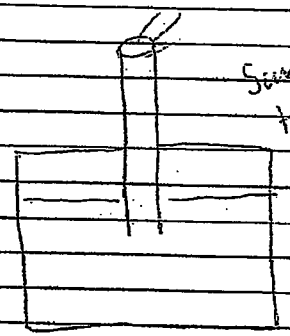
Discussion

Mark K. Reports to President of company

Does LDAR monitoring monthly - Mark K.

No marking on equipment in benzene service for Subpart L

Weak Liquor Storage Tank - covered?



Subpart V
L.D. gravity line from still to storage tank
L.D. Bisque benzene pump
Marked with in benzene service, but not a unique number
Reported on Subpart L monthly report

04/14/09

Survey condensers

Visual observation of lines monthly

No stack tests / performance tests have been conducted

04/15/09

The Weak Liquor Storage tank does not have a top on it.

Equalization Tank is also an open top tank.

Coal analysis done on-site, pulverized coal looks like sand, collect about 2 lbs. to sample

Volatile content % - do a small scale test in a muffle furnace.
Combustible
Compare weight before & after
Sample has been dried (moisture removed)

Ash Content - wafer looking ceramic like
Put in muffle furnace for 9 hrs.
Let O2 in - % weight of Ash

Fixed Carbon - Mathematical computation
100 - volatiles - ash = Fixed Carbon

Sulfur - Total Sulfur in special machine

DSPM - acceptability of coal blend to make good coke

Samples taken daily - Monday thru Friday

Fdry Mix - Foundry Mix
Industrial Mix - Furnace Mix

EXHIBIT L

SAWANDA COKE CORPORATION

SAFETY ORIENTATION CHECKLIST FOR NEW OR TRANSFERRED EMPLOYEES, CONTRACTORS, & VENDORS

Name of Employee:_____ **Department:**_____ **Clock #** _____

A. Review Work Rules, Sign Plant Rules ___

B. Personal Protective Equipment
Purpose, Use, Storage, and Care of:
1. Work Clothes ___
2. Safety Glasses ___
3. Hard Hat ___
4. Gloves ___
5. Safety Shoes ___
6. Eye Protection ___
7. Respirators ___
   a. Coke Oven Emissions ___
8. Hearing Protection ___
9. Goggles ___

C. Mandated Safety Programs
1. Hazard Communication Program ___
   a. Types Chemicals ___
   b. MSDS/Labels ___
   c. OSHA 1910.1029 ___
2. Lockout/Tagout Training ___
3. Confined Space ___
4. Bloodborne Pathogens ___
5. Hydration ___

D. Emergency Equipment
Location and use of:
1. Safety Shower ___
2. Eye-Wash ___
3. First-Aid Station ___
4. Fire Equipment ___

E. Emergency Procedures
1. Personal Injury ___
2. Fire ___
3. Spill ___
4. Evacuation ___

F. Reporting Injury & Illness
1. Importance/Urgency ___
2. Telephone Numbers ___
   a. Day/Night ___

G. Job Assignment
1. Housekeeping ___
2. Chemical Goggle Area ___
3. Lifting ___
4. Using Ladders ___
5. Pinch Points ___
6. Slippery Surfaces ___

H. Personal Hygiene
1. Shower Requirements ___
2. Changing Clothes ___
3. Eating Areas ___
4. Washing Prior to Eating ___
5. Locker Policy ___
6. PPE to Remain in Plant ___

I. Motor Vehicle Equipment
1. Plant Vehicle Rules ___
2. Forklifts ___
3. Driver Qualifications ___
4. Reporting Accidents ___

J. Other Items Discussed
1. Smoking ___
2. Horseplay ___
3. Fighting ___
4. Sleeping on the Job ___
5. Contact Lenses ___
6. Substance Abuse Policy ___
7. Harassment Policy ___
8. Quality System Intro ___
9. Long Sleeves Required ___
10. Cell phones ___

K. Contractors
1. Discussed area of plant that contractor will be working (must remain in area) ___
2. Abide with all Federal, State, and Local Laws and regulations ___
3. Safety Orientation Movie ___

The above was discussed with me and understood _____ Date: _____

Locker assignment:_____ Tag assignment (LO/TO):_____

Job Requirement Checklist (Backdoor Machine Operator)

1. **Safety Requirements**
   - Y Was explained about our safety first policy
   - Y Was informed about restricted areas including use of PPE.
   - Y Was informed about motion alarms
   - Y Was informed on how to locate the GF in case of problems
   - Y Was informed about cleanup and cleanup areas
   - Y Was informed about radio etiquette and protocol
   - Y Was informed about heat sickness
   - Y Knows about the interlock system
   - Y Knows to have door latches down all the way
   - Y Knows to be very cautious before swinging the extractor around

2. **Job Responsibilities**
   - Y Understands the use of the schedule board
   - Y Understands the importance of lining up correctly
   - Y Can tell if extractor hooks are all the way under or not
   - Y Understands the importance of having the Coke Guide locked in
   - Y Knows to look for ovens that need patching
   - Y Knows to alert the GF of ovens with dark walls
   - Y Knows not to throw drag or garbage on the QuenchTracks
   - Y Understands why doors can't be left off too long
   - Y Was informed not to use reverse to stop the machine
   - Y Understands the importance of gasketing doors

3. **Work Instructions and Procedures**
   - Y Was shown the location and use of all controls on the machine
   - Y Has demonstrated the proper speed and stopping of the Backdoor Machine
   - Y Is cautious when removing and replacing doors
   - Y Knows about washer combinations
   - Y Knows the importance of locking in the coke guide
   - Y Is cautious when an oven is being pushed
   - Y Knows how to line up correctly
   - Y Knows how to tell if he has too many or too few washers
   - Y Knows how to tell if a door is too high or too low
   - Y Knows how to lower a door
   - Y Knows how to safely put doors in the repair rack

4. **Emergency Procedures**
   - Y Understands and can explain what to do in case of a problem
   - Y Knows how to locate the GF
   - Y Knows the location of the fire extinguisher on the BDM.
   - Y Knows how to prevent emergency situations by:
     1. Preventing doors from being dropped
     2. Being cautious when removing and replacing doors
     3. Being cautious when an oven is being pushed

5. Quality Issues

- Y Knows where Tonawanda Coke's Quality policy is posted
- Y Knows where Work Instructions are posted
- Y Knows the importance of looking at the oven walls for temperature
- Y Knows not to throw drags or garbage on the Quench Tracks

6. Environmental Issues

- Y Understands the importance of gasketing doors
- Y Understands the importance of keeping the top sealed
- Y Understands the charging process to eliminate emissions
- Y Knows the correct procedure to sweep the battery top
- Y Knows how to use the jumper pipe
- Y Knows to look for door fires and put out immediately

7. Machine Maintenance

- Y Knows to keep the machine and bench clean and free of obstructions
- Y Knows to turn the hydraulic pump off when not in use - not in winter time.
- Y Knows to notify the GF of an electrical or mechanical problem
- Y Knows not to reverse the direction control to stop the BDM

Overall Performance Rating Qualified X Disqualified _____

General Foreman P. Dolan Date 12/20/05

Length of training period: 2 Days

1. Overall machine performance (rate on a scale of 1 to 10, 10 being outstanding) 9
2. Overall knowledge of the job 9
3. Overall safety performance 10
4. Areas which need improvement and comments none

Trainer Douglas 476 Date 12/20/05

1. Overall machine performance rating (1 to 10) 10
2. Additional comments _____

I have been trained for the position of Backdoor Machine Operator and can effectively perform the job:

W. M. [signature] 623 12/20/05

(Employee Signature) (Clock Number) (Date)

Tonawanda Coke June 2003 Name [illegible] 1

Job Requirement Checklist (Quench Car Operator)

1. **Safety Requirements**
   - X Was explained about our safety first policy
   - X Was informed about restricted areas including use of PPE.
   - X Was informed about motion alarms
   - X Knows when to blow his whistle
   - X Was informed on how to locate the GF in case of problems
   - X Was informed about cleanup and cleanup areas
   - X Was informed about radio etiquette and protocol
   - X Was informed about heat sickness
   - X Knows about the interlock system
   - X Knows to look before he dumps coke on the wharf
   - X Knows to look before moving the Quench Car
   - X Knows to notify the GF if the front of wharves need cleaning

2. **Job Responsibilities**
   - X Understands the use of the schedule board
   - X Understands what it means to catch ovens on time
   - X Checks gates before every push
   - X Understands the importance of lining up correctly
   - X Knows how to catch an oven evenly
   - X Knows how to stop a push
   - X Knows how to keep foundry separate from indy
   - X Knows to use #2 Tower unless notified not to
   - X Knows to check the hot car pin frequently
   - X Knows to alert the GF of ovens with dirty pushes
   - X Knows not to throw garbage on the QuenchTracks
   - X Was informed not to use reverse to stop the machine

3. **Work Instructions and Procedures**
   - X Was shown the location and use of all controls on the machine
   - X Has demonstrated the proper speed and stopping of the Quench Car
   - X Knows how to read the schedule board
   - X Is cautious when an oven is being pushed
   - X Knows how to line up correctly
   - X Knows how to dump an oven on the wharf without spilling
   - X Knows how to assist in charging ovens

4. **Emergency Procedures**
   - X Understands and can explain what to do in case of a problem
   - X Knows how to locate the GF
   - X Knows the location of the fire extinguisher on the Quench Car.
   - X Knows to put chains on hot car gates if power is lost
   - X Knows how to prevent emergency situations by:
     1. Being cautious when an oven is being pushed
     2. Using appropriate speed when traveling
     3. Using whistle to warn others

5. Quality Issues

- X Knows where Tonawanda Coke's Quality policy is posted
- X Knows where Work Instructions are posted
- X Knows the importance of keeping foundry and indy coke separate
- X Knows to use the right quench button for foundry or indy
- X Knows not to put too much water on coke
- X Knows to notify GF if an oven is green

6. Environmental Issues

- X Understands the importance of keeping the top sealed
- X Understands the charging process to eliminate emissions
- X Knows the correct procedure to sweep the battery top
- X Knows how to use the jumper pipe
- X Knows to notify GF if an oven is green
- X Knows to look for door fires and notify BDM operator immediately

7. Machine Maintenance

- X Knows to keep the machine clean and free of obstructions
- X Knows to notify the GF of an electrical or mechanical problem
- X Knows not to reverse the direction control to stop the Quench Car
- X Notify GF if tower sprays are plugged
- X Knows to drain the air compressor once a shift
- X Knows to check the compressor oil once a shift

Overall Performance Rating Qualified ✓ Disqualified _____

General Foreman TUCKER Date 11/30/06

Length of training period: 5 Days

1. Overall machine performance (rate on a scale of 1 to 10, 10 being outstanding) 10
2. Overall knowledge of the job 9.5
3. Overall safety performance 9.5
4. Areas which need improvement and comments NONE. GREAT LEAD MAN.

Trainer MILES Date 11/30/06

1. Overall machine performance rating (1 to 10) 10
2. Additional comments —

I have been trained for the ~~position~~ of Quench Car Operator and can effectively perform the job:

X _____ 572 11/30/06

(Employee Signature) (Clock Number) (Date)

B-crew Mike Johnson 6043
Tonawanda Coke Co. June 2003 LARGE CAR.

Job Requirement Checklist

1. Safety Requirements

Y
- __ Was informed about restricted areas including use of PPE.
- __ Was informed about motion alarms
- __ Was informed on how to locate the GF in case of problems
- __ Was informed about cleanup and cleanup areas
- __ Was informed about radio etiquette
- __ Was informed about heat sickness
- __ Was shown the correct way to clean goosenecks to eliminate back injuries
- __ Was informed about the operation of aspirating steam and damper arms
- __ Was informed about open charge holes, stepping on lids and flue caps
- __ Understands the importance of not raising the boots before the chuckdoor is closed

2. Job Responsibilities

Y
- __ Was explained about our safety first policy
- __ Understands the use of the schedule board
- __ Understands the Charge Car paperwork that must be filled out
- __ Can explain the correct bins to get coal from and when
- __ Understands the importance of filling the ovens with coal
- __ Understands the importance of turning the aspirating steam off after the charge

3. Work Instructions and Procedures

Y
- __ Was shown the location and use of all controls on the machine
- __ Was shown how to make sealing mud and how much
- __ Understands the importance of keeping the goosenecks clean
- __ Has demonstrated the correct sequence of actions while stage charging
- __ Has demonstrated the proper speed and stopping of the Charge Car
- __ Has demonstrated the proper lining up of the machine to get coal
- __ Knows how to operate the Spare Charge Car — not covered Yet

4. Emergency Procedures

Y
- __ Understands and can explain what to do in case of a problem
- __ Was informed not to charge an oven without aspirating steam
- __ Was informed of how to correct the problem of boots drifting down and knocking off charge lids
- __ Knows the location of fire extinguishers on the battery top
- __ Was informed of the reason not to charge an oven until both doors are on
- __ Was informed about why excessive fire comes out of a charge hole after charging (loss of steam, needs to be releveled, or plugged standpipe)

5. Quality Issues

Y
- __ Knows where Tonawanda Coke's Quality policy is posted
- __ Knows where Work Instructions are posted
- __ Understands the importance of charging an oven with the right coal
- __ Understands the importance of not mixing coals

6. Environmental Issues

Y
- Realizes the importance of stage charging to reduce emissions
- Knows the reason why a certain number of ovens are dampered off
- Knows the importance of keeping goosenecks clean
- Knows how to clean gooseneck sprays
- Understands why leaks need to be sealed
- Understands why sweeping with only one lid off reduces emissions

7. Machine Maintenance

Y
- Knows to keep the machine clean and free of obstructions
- Knows to turn the hydraulic pump off when not in use
- Knows why not to leave the Charge Car parked on the battery when not in use
- Knows not to hang mud buckets on the electric motors
- Knows to notify the GF of an electrical or mechanical problem
- Knows how to clean the hoppers out in cold weather
- Knows not to reverse the direction control to stop the car

Overall Performance Rating Qualified X Disqualified ____

General Foreman [signature] Date 9/8/07

Length of training period: 16 Days

1. Overall machine performance (rate on a scale of 1 to 10, 10 being outstanding) 8
2. Overall knowledge of the job 8
3. Overall safety performance 8
4. Areas which need improvement and comments ____
   Scheduling

Trainer [signature] Date 9/8/07

1. Overall machine performance rating (1 to 10) ____
2. Additional comments ____

I have been trained for the position of Charge Car Operator and can effectively perform the job:

[signature] 603 9/8/07
(Employee Signature) (Clock Number) (Date)

Job Requirement Checklist (Backdoor Machine Operator)

1. **Safety Requirements**
   - X Was explained about our safety first policy
   - X Was informed about restricted areas including use of PPE.
   - X Was informed about motion alarms
   - X Was informed on how to locate the GF in case of problems
   - X Was informed about cleanup and cleanup areas
   - X Was informed about radio etiquette and protocol
   - X Was informed about heat sickness
   - X Knows about the interlock system
   - X Knows to have door latches down all the way
   - X Knows to be very cautious before swinging the extractor around

2. **Job Responsibilities**
   - X Understands the use of the schedule board
   - X Understands the importance of lining up correctly
   - X Can tell if extractor hooks are all the way under or not
   - X Understands the importance of having the Coke Guide locked in
   - X Knows to look for ovens that need patching
   - X Knows to alert the GF of ovens with dark walls
   - X Knows not to throw drag or garbage on the QuenchTracks
   - X Understands why doors can't be left off too long
   - X Was informed not to use reverse to stop the machine
   - X Understands the importance of gasketing doors

3. **Work Instructions and Procedures**
   - X Was shown the location and use of all controls on the machine
   - X Has demonstrated the proper speed and stopping of the Backdoor Machine
   - X Is cautious when removing and replacing doors
   - X Knows about washer combinations
   - X Knows the importance of locking in the coke guide
   - X Is cautious when an oven is being pushed
   - X Knows how to line up correctly
   - X Knows how to tell if he has too many or too few washers
   - X Knows how to tell if a door is too high or too low
   - X Knows how to lower a door
   - X Knows how to safely put doors in the repair rack

4. **Emergency Procedures**
   - X Understands and can explain what to do in case of a problem
   - X Knows how to locate the GF
   - X Knows the location of the fire extinguisher on the BDM.
   - X Knows how to prevent emergency situations by:
     1. Preventing doors from being dropped
     2. Being cautious when removing and replacing doors
     3. Being cautious when an oven is being pushed

5. Quality Issues

- X Knows where Tonawanda Coke's Quality policy is posted
- X Knows where Work Instructions are posted
- X Knows the importance of looking at the oven walls for temperature
- X Knows not to throw drags or garbage on the Quench Tracks

6. Environmental Issues

- X Understands the importance of gasketing doors
- X Understands the importance of keeping the top sealed
- X Understands the charging process to eliminate emissions
- X Knows the correct procedure to sweep the battery top
- X Knows how to use the jumper pipe
- X Knows to look for door fires and put out immediately

7. Machine Maintenance

- X Knows to keep the machine and bench clean and free of obstructions
- X Knows to turn the hydraulic pump off when not in use
- X Knows to notify the GF of an electrical or mechanical problem
- X Knows not to reverse the direction control to stop the BDM.

Overall Performance Rating Qualified X Disqualified _____

General Foreman John Bon Date 6/16/08

Length of training period: 7 Days

1. Overall machine performance (rate on a scale of 1 to 10, 10 being outstanding) 7
2. Overall knowledge of the job 7
3. Overall safety performance 9
4. Areas which need improvement and comments JUST MORE REPETITION STOP IN DOOR ROOM WHEN OPERATION IS DONE

Trainer [signature] Date 6/16/08

1. Overall machine performance rating (1 to 10) 7
2. Additional comments _____

I have been trained for the position of Backdoor Machine Operator and can effectively perform the job:

X [signature] 671 6/16/08
(Employee Signature) (Clock Number) (Date)

Job Requirement Checklist (Quench Car Operator)

1. **Safety Requirements**
   - Was explained about our safety first policy
   - Was informed about restricted areas including use of PPE.
   - Was informed about motion alarms
   - Knows when to blow his whistle
   - Was informed on how to locate the GF in case of problems
   - Was informed about cleanup and cleanup areas
   - Was informed about radio etiquette and protocol
   - Was informed about heat sickness
   - Knows about the interlock system
   - Knows to look before he dumps coke on the wharf
   - Knows to look before moving the Quench Car
   - Knows to notify the GF if the front of wharves need cleaning

2. **Job Responsibilities**
   - Understands the use of the schedule board
   - Understands what it means to catch ovens on time
   - Checks gates before every push
   - Understands the importance of lining up correctly
   - Knows how to catch an oven evenly
   - Knows how to stop a push
   - Knows how to keep foundry separate from indy
   - Knows to use #2 Tower unless notified not to
   - Knows to check the hot car pin frequently
   - Knows to alert the GF of ovens with dirty pushes
   - Knows not to throw garbage on the QuenchTracks
   - Was informed not to use reverse to stop the machine

3. **Work Instructions and Procedures**
   - Was shown the location and use of all controls on the machine
   - Has demonstrated the proper speed and stopping of the Quench Car
   - Knows how to read the schedule board
   - Is cautious when an oven is being pushed
   - Knows how to line up correctly
   - Knows how to dump an oven on the wharf without spilling
   - Knows how to assist in charging ovens

4. **Emergency Procedures**
   - Understands and can explain what to do in case of a problem
   - Knows how to locate the GF
   - Knows the location of the fire extinguisher on the Quench Car.
   - Knows to put chains on hot car gates if power is lost
   - Knows how to prevent emergency situations by:
     1. Being cautious when an oven is being pushed
     2. Using appropriate speed when traveling
     3. Using whistle to warn others

5. Quality Issues

- ✓ Knows where Tonawanda Coke's Quality policy is posted
- ✓ Knows where Work Instructions are posted
- ✓ Knows the importance of keeping foundry and indy coke separate
- ✓ Knows to use the right quench button for foundry or indy
- ✓ Knows not to put too much water on coke
- ✓ Knows to notify GF if an oven is green

6. Environmental Issues

- ✓ Understands the importance of keeping the top sealed
- ✓ Understands the charging process to eliminate emissions
- ✓ Knows the correct procedure to sweep the battery top
- ✓ Knows how to use the jumper pipe
- ✓ Knows to notify GF if an oven is green
- ✓ Knows to look for door fires and notify BDM operator immediately

7. Machine Maintenance

- ✓ Knows to keep the machine clean and free of obstructions
- ✓ Knows to notify the GF of an electrical or mechanical problem
- ✓ Knows not to reverse the direction control to stop the Quench Car
- ✓ Notify GF if tower sprays are plugged
- ✓ Knows to drain the air compressor once a shift
- ✓ Knows to check the compressor oil once a shift

Overall Performance Rating Qualified ✓ Disqualified _____

General Foreman [signature] Date 8-22-09

Length of training period: 40 HRS Days

1. Overall machine performance (rate on a scale of 1 to 10, 10 being outstanding) 7
2. Overall knowledge of the job 8
3. Overall safety performance 9
4. Areas which need improvement and comments Using All of Car

Trainer Phil-C Date 8-22-09

1. Overall machine performance rating (1 to 10) 7
2. Additional comments _____

I have been trained for the position of Quench Car Operator and can effectively perform the job: Marcus Richardson 640 8/22/09

(Employee Signature) (Clock Number) (Date)

TRAINING PROGRAM

PURPOSE:

1) To initiate work practices which will eliminate emissions.

2) Standardize job procedures, practices, and responsibilities so that all shifts will be doing the same thing each and every time.

3) Comply with regulatory agencies. We cannot operate being fined $25,000 per day.

4) Promote safety and efficiency.

WHAT HAS TO BE DONE?

1) Eliminate emissions. We will be allowed only:

   a) 1.44 leaking charge hole lids.

   b) 1.8 standpipe, gooseneck, and cap leaks.

   c) 6.6 out of 120 doors leaking.

   d) 12 seconds of emissions per charge for 5 charges.

HOW WILL THIS TRAINING WORK?

1) Initial training sessions will be held which will emphasize job procedures, responsibilities, and safety.

2) Refresher training, additional training, and on the job training sessions will be held.

3) Auditing, monitoring, and inspections will be made.

WHEN WILL THIS TRAINING TAKE PLACE?

NOW. January 1st is too late to start. From this day forward procedures to eliminate emissions must be used. Starting January 1, 1996 we will have a person in the plant monitor emissions every day thereafter.

COKE OVEN NESHAP
SUMMARY OF RECOMMENDED RULE AND PREAMBLE

I. Numbers

A. MACT and LAER: All numbers are rolling averages of the last thirty readings; that is, if no reading is taken on a day, nothing is entered for that day. For charging, a daily set of readings consists of five consecutive charges. If more readings (or sets of readings) are taken in a day, the average of all values taken in the day will be used in the rolling average calculation. The states may be delegated responsibility for conducting the daily readings.

	MACT		LAER		
	12-31-95	Beyond 2003 (must meet residual risk)	11-15-93	1-1-98	1-1-07*
LIDS PLL	0.6	lower of 0.6 or residual risk	0.83	0.4	0.4 or lower based on 2007 result
OFFTAKES PLO	3.0	lower of 3.0 or residual risk	4.2	2.5	2.5 or lower based on 2007 result
CHARGING (log) s/charge	12	lower of 12 or residual risk	12	12	12 or lower based on 2007 result
DOORS PLD		lower of			
• TALL	6.0	5.5	7.0	4.3	4.0
• SHORT/INT	5.5	5.0	7.0	3.8	3.3
• FOUNDRY	5.5	5.0 or residual risk	7.0	4.3	4.0 or lower based on 2007 result

* These limits to be effective 01/01/07, compliance by 01/01/10. EPA may lower numbers as outlined in Section 112(f)(8)(c).

B. New source MACT based on nonrecovery. However, if new recovery technology is developed, MACT will be determined on a case-by-case basis. The resulting emissions would be less than those associated with LAER.

TRAINING SESSION

CHARGING PROCEDURE:

1) Operator asks GF which bins to get coal from.

2) Operator copies oven schedule from chalkboard in the schedule room and notes foundry/indy charges.

3) Operator checks to see if hoppers are full and if brooms and sealing mud are available.

4) Operator checks the hydraulic pump for proper operation, checks to see if the tracks are clear, and takes the car out onto the battery and positions it to the east of the oven to be charged.

5) After being notified by the Pusher Op. and the Backdoor Machine Op. that their doors are on, the Charge Car Op. removes the pipe cap from the steam jet on the oven just pushed and reams out the steam jet with the drill rod tool. After replacing the cap, the operator looks inside the gooseneck, checks the spray, and cleans as necessary.

6) The operator then lowers the gooseneck cap and seals it. He then sweeps around the standpipe and charge hole.

7) The operator turns the steam on the jumper oven (adjacent oven to the west of the empty oven), goes to the jumper pipe and removes the jumper lids on the jumper oven and oven to be charged and lowers the jumper pipe over the holes.

8) The operator turns the steam on and pushes the damper arm up on the oven to be charged and removes the #1 & #3 charge lids. While pulling the lids, the operator checks for sufficient aspiration and excessive carbon buildup and cleans as necessary. He removes the #2 lid, checks for carbon, replaces lid, and attaches lid puller bar to the lid.

9) The operator brings the car forward and positions it over the charge holes and lowers all boots. He notifies the other operators by saying, "CHARGING." He raises #1 and #3 plugs and turns on #1 and #3 turntables. When #1 hopper empties, he lowers #1 plug and turns off #1 turntable. The operator raises #1 boot, slides #1 lid on, then lowers #1 boot.

10) When #3 hopper empties, he lowers #3 plug and turns off #3 turntable. The operator raises #3 boot, the Quench Car/ Backdoor Machine Operator slides the #3 lid on, and the operator lowers #3 boot. The operator raises #2 boot, pulls #2 lid off with the lid puller bar, then lowers the boot. He raises #2 plug and starts #2 turntable.

11) After the #2 turntable runs for approximately 40 seconds, the hopper will be about three quarters empty. The operator then tells the Pusher Operator to "LEVEL" and the coal in the oven is leveled.

12) When the #2 hopper is empty the operator lowers the #2 plug, shuts off the #2 turntable and tells the Pusher Operator to, "CLOSE THE CHUCKDOOR." After the Pusher Operator signals that the chuckdoor is closed, the Charge Car Operator lifts the #2 boot, slides the #2 lid on, then lowers the boot. The Quench Car/ Backdoor Machine Operator raises the jumper pipe with the chainfall and the Charge Car Operator slides the jumper lids on. The operator then lifts all boots and moves the car back (to the east).

13) Only one charge lid can be off at a time, increasing aspiration and eliminating emissions.

14) The Charge Car Operator sweeps and seals the #1 & #2 lids. The Quench Car/Backdoor Machine Operator slides the jumper pipe out of the way and seals the jumper lids and #3 lid. He then turns the steam off and checks for leaks and reseals if necessary. The Charge Car Operator moves the jumper pipe and positions it for the next oven. He then goes to the next oven to be dampered off, pulls the damper arm down, raises the gooseneck cap, cleans the gooseneck with the cleaning tool, and lights it off with a striker. He then takes the car to get coal for the next oven.

15) All emissions must be sealed before going to the next oven. If excessive emissions occur at any time during the charging process, notify the GF immediately.

16) Supervision reserves the right to make any changes to charging procedures, due to varying conditions, which will enhance safety, efficiency, and eliminate emissions.

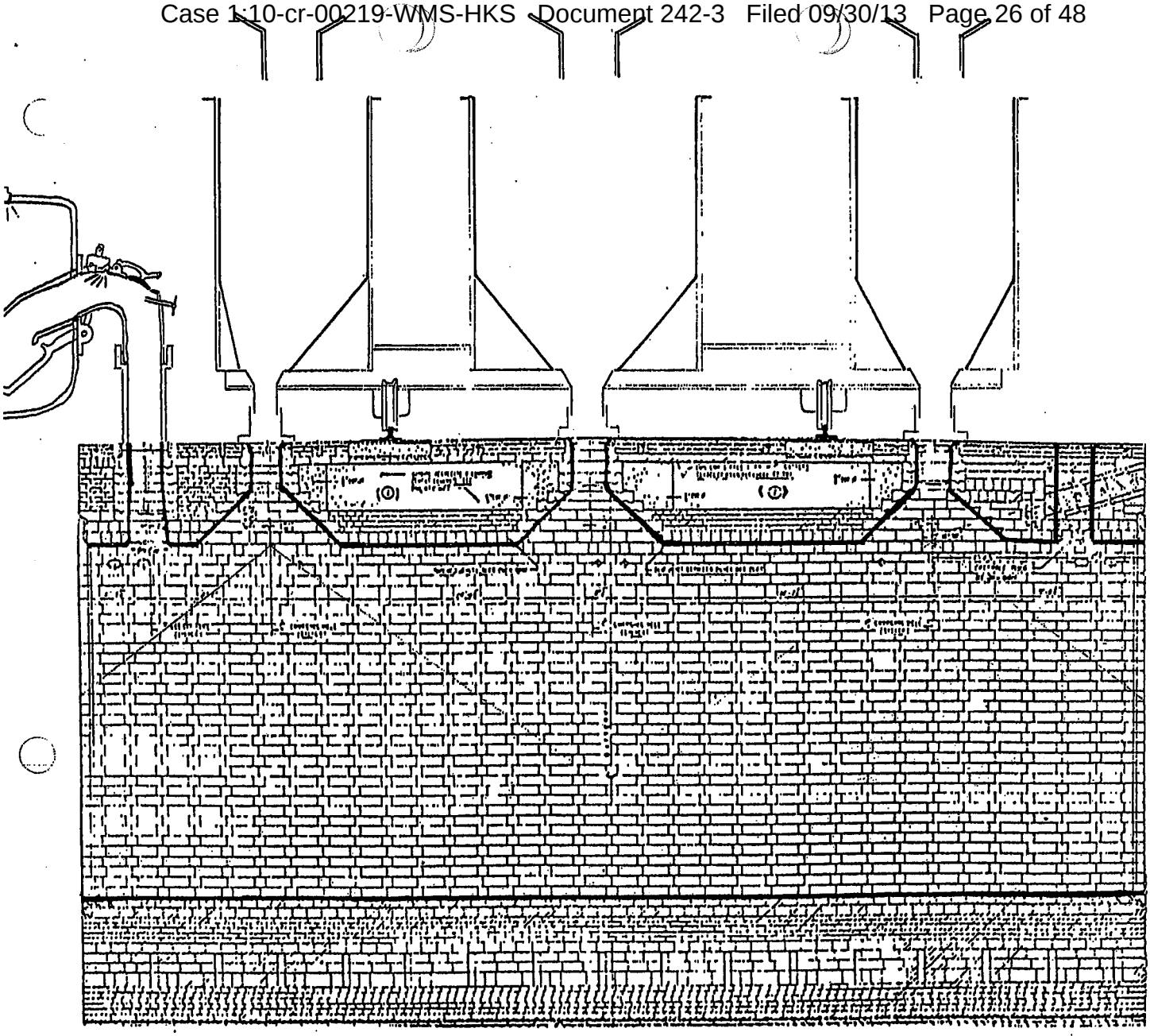


Fig 1 - This diagram shows what the coal level would look like inside an oven after charging the north & south hoppers of the charge car. The middle hopper is still full.

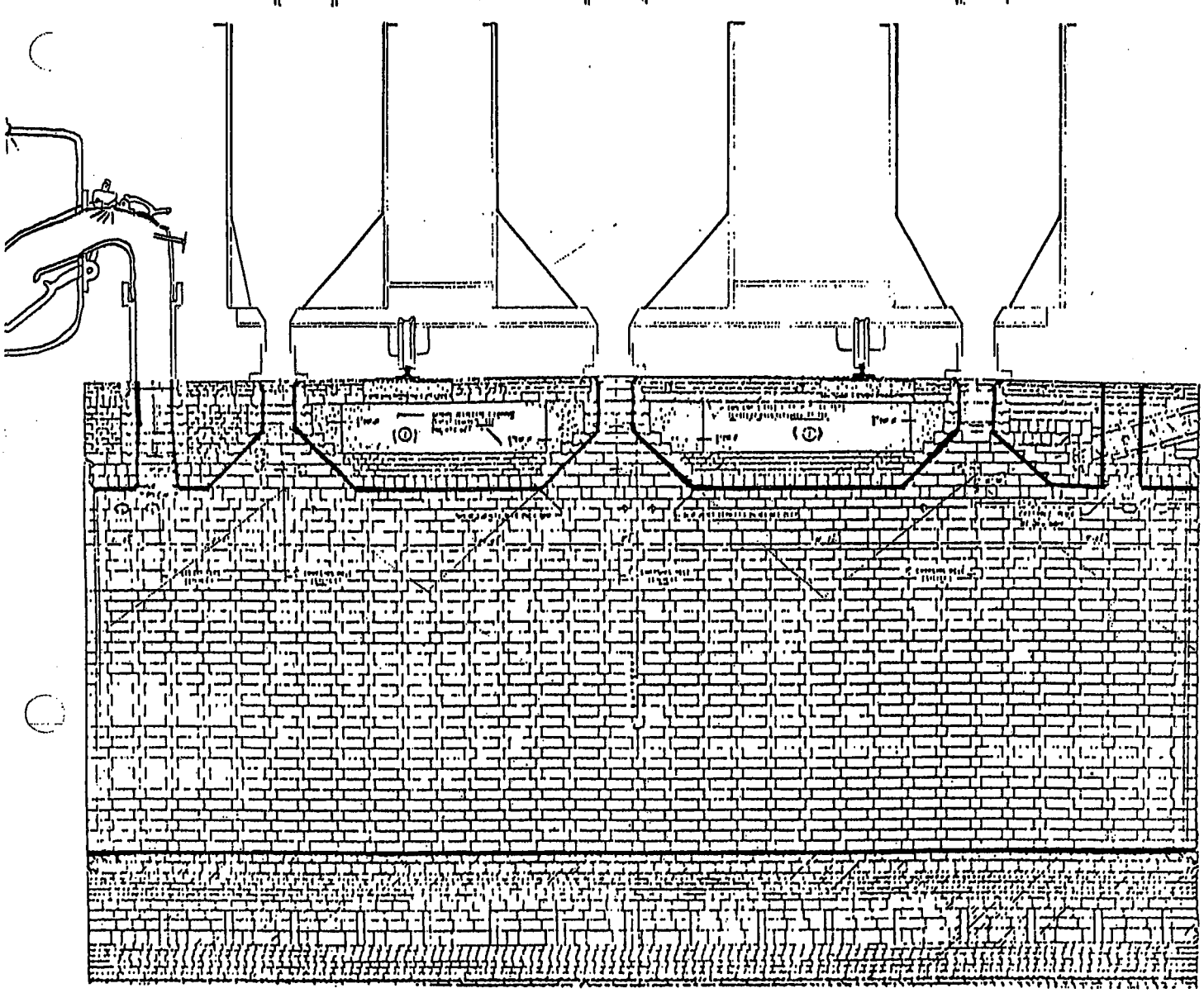
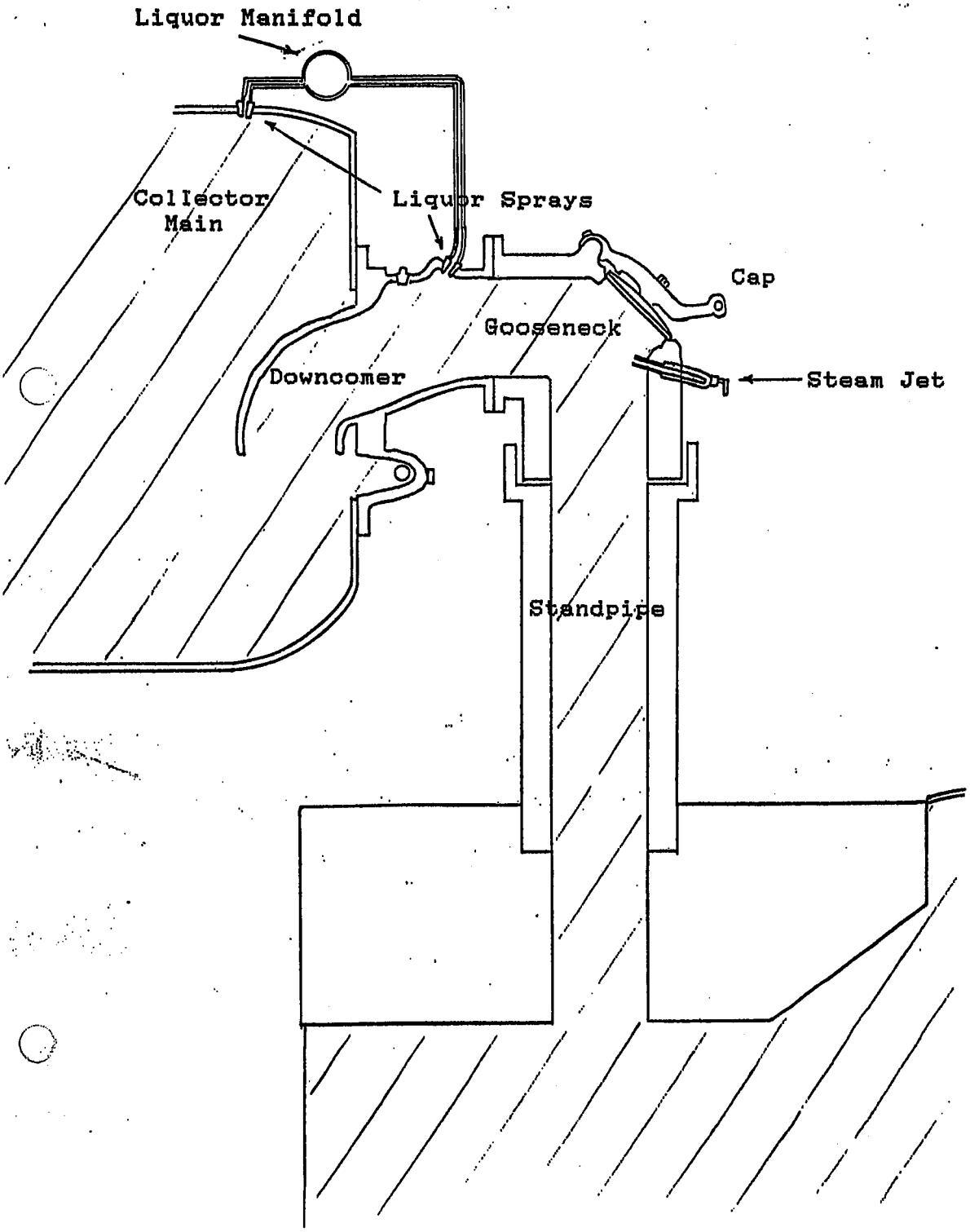
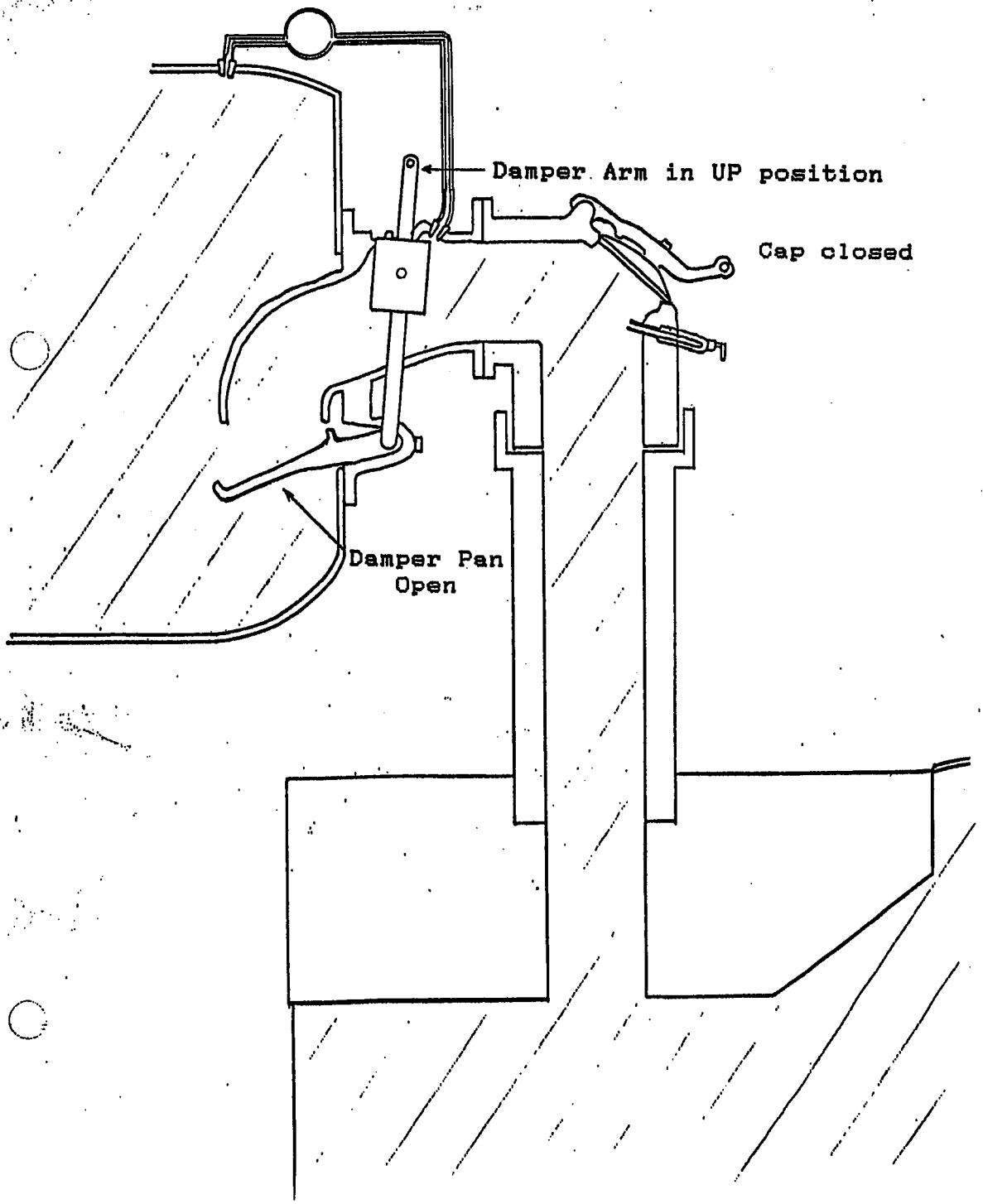


Fig 2 - This diagram shows what the coal level would look like inside an oven after the north & south hoppers of the charge car are empty and the middle hopper is almost empty. When the leveling bar is brought in to level the coal, the middle hopper will empty out and the coal level will be flat across the top.

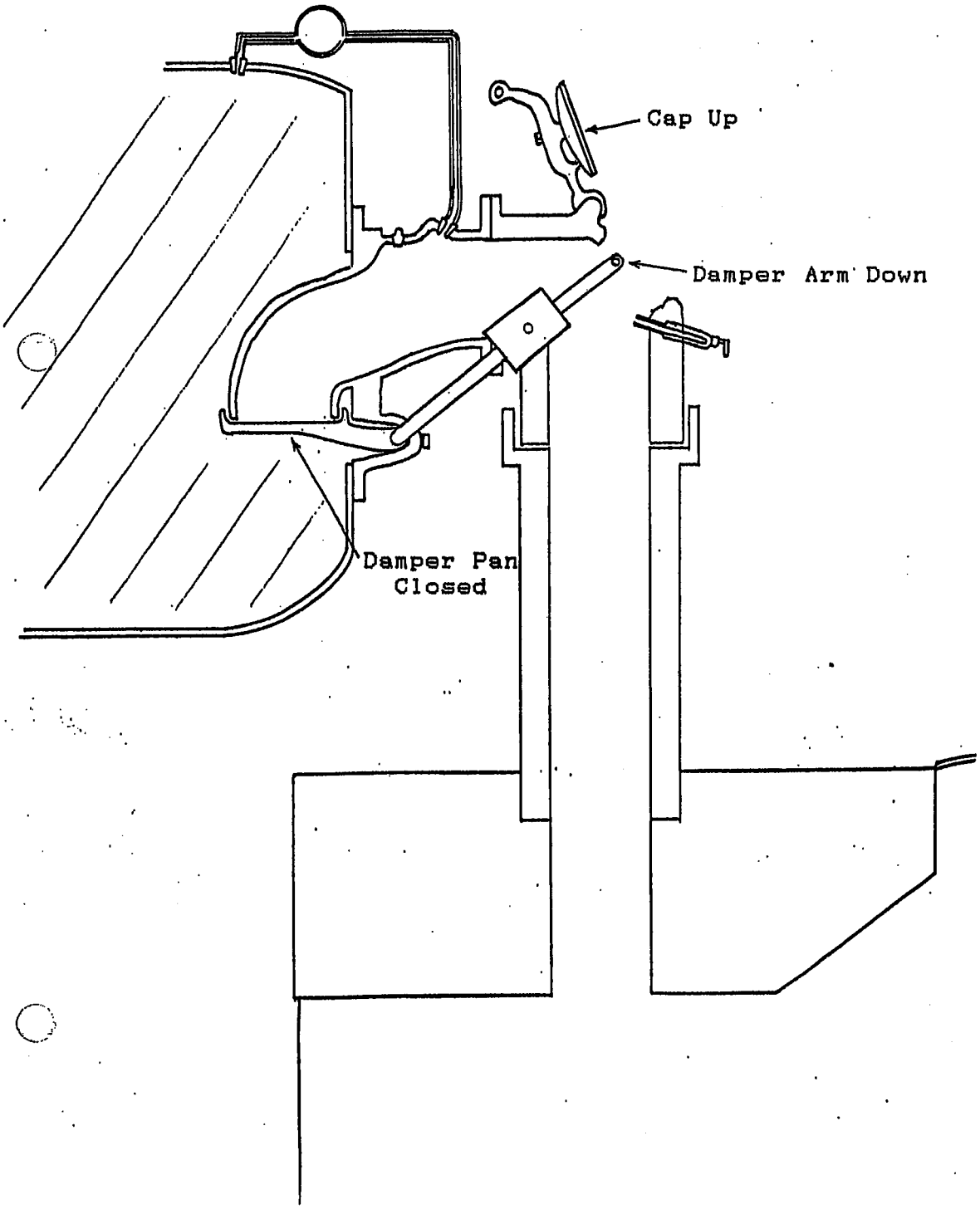
This diagram shows the various parts of the standpipe and the way the gas flows from the oven chamber to the collector main. The liquor sprays are used to cool the gas and to keep the downcomer clean. The steam jet is used to create a suction when the oven is being charged. Both must be kept clean for optimum performance. The damper arm and pan are left off the diagram for clarity.



This diagram shows a standpipe with the damper arm in the up position. This allows the gas from the oven chamber to flow freely into the standpipe, through the gooseneck and downcomer, and into the collector main. Notice the position of the standpipe cap, damper arm, and damper pan. During the charging process and through the entire coking cycle, the standpipe is left in this manner.



This diagram shows an oven that has been dampered off. The damper arm is down, the damper pan is closed, and the cap is up. With the damper pan closed, gas in the collector main is kept at a positive pressure and cannot escape because liquor from the sprays sits in the bottom of the pan and froms a liquor seal. With the standpipe cap up, the pressure inside the oven chamber is equal the outside pressure. At the end of the coking cycle when the oven is ready to be pushed, the oven is dampered off in this way to prevent gas from leaving the main and for decarbonization.



Job Responsibilities - Charge Car Operator

1) Operating the car in a safe and careful manner.

2) Working cooperatively with other operators to insure safe and efficient operation of the battery.

3) Checking the pushing schedule, making sure the correct oven is dampered off. Making sure of the correct place to go for coal in the coal bins. Making sure the car is full after loading and empty after charging. Making sealing mud.

4) Making sure that the gooseneck, spray, steamjet, and charge holes are clean.

5) Making sure ovens are charged by the correct procedures assuring safety, efficiency, and eliminating emissions.

6) Making sure aspirating steam is turned off after the charge and steam chart has been checked.

7) Cleaning and sealing charge hole lids and castings as necessary.

8) Maintaining the oven top in a clean condition, sweeping after every charge and as necessary.

9) Reporting all abnormal operating or equiptment conditions promptly to the foreman.

10) Being alert for leaks and fires, either with sealing mud or reporting them to the foreman, depending on the circumstances.

11) Operating equiptment and performing job duties in accordance with the standard operating procedures.

12) Following all plant, area, and safety rules.

13) Performing other duties as directed by supervision.

Safety and Area Rules

1) Racal helmets must be worn. Flame retardant clothing, safety shoes are required on the battery.

2) Do not stand on or climb over railings or other parts of the charge car and battery top that are intended to be safety restrictions.

3) Use care in the use of aspirating steam, cleaning goosenecks, and dampering ovens off.

4) Do not stand on charge hole lids at any time.

5) Be alert for open charge holes and/or flue caps.

6) Keep the charge car and battery top clean and free of unnecessary tools, trash, hoses, etc.

7) Make sure motion alarm is working on the car. Be aware of other personnel on the battery top while moving the car.

8) Bring any safety, mechanical, electrical, or operational concern you may have to the attention of your foreman.

Quench Locomotive Operator Procedures

1) Quench locomotive operator is responsible for letting the other operators know when to push ovens and when to take breaks. He will also inform the other operators of any changes or pertinent information while in the process of pushing and charging ovens.

2) Before the start of the shift the operator checks with the GF for any changes or additions in battery operating conditions or procedures.

3) Operator copies oven schedule from chalkboard in the schedule room.

4) Operator checks locomotive and car: gates closed, air pressure, motion alarm, brakes, car/loco coupling, quench car empty, and tracks clear.

5) Operator sounds whistle indicating start of shift and that the quench car is about to move.

6) Operator proceeds with the quench car to the oven to be pushed and lines up accordingly.

7) After seeing that the backdoor machine operator has racked into the correct oven and hearing him say "RACKED IN" the quench car operator calls for the oven. Example: "PUSH No. 77" The pusher operator will say "PUSHING No. 77" When the quench car operator sees that the coke has entered the guide witout a problem, he says, "IN THE GUIDE" When he sees it in the car, he says, "WAGON." Nothing else should be heard over the radio while the oven is being pushed to avoid confusion and for safety factors.

8) If, in the process of catching the oven while it was being pushed, a problem developed, the operator would have said, "STOP THE PUSH" and did what he had to to solve the problem depending on the circumstances.

9) After catching the oven the operator, using suitable speed and caution, proceeds to the quench tower and positions the car for quenching. After pressing the correct button to release the water, the operator may have to move the car in the tower to provide an even quench, depending on the conditions.

10) After quenching and draining the oven for the correct amount of time, the operator sounds the whistle indicating to others that he is about to move. He moves out of the quench tower and proceeds to the wharf or to the proper place on the battery where the safety gate is located.

11) He proceeds to the battery top and follows proper charging procedures and cautions.

12) When the charge car operator lifts #3 boot, the quench car operator slides #3 lid on. Then he raises the jumper pipe with a chainfall while the Charge Car Operator slides the jumper lids on with a lid bar. He sweeps and seals the jumper lids and the #3 lid.

13) Supervision reserves the right to make changes, due to changing conditions, to any procedures in order to eliminate emissions, enhance efficiency, and promote safety.

Job Responsibilities - Quench Car Operator

1) Working cooperatively with other operators to insure safe and efficient operation of the battery.

2) Checking the oven pushing schedule and finding out which wharf and quench tower to use. Calling for the ovens according to the scheduled time.

3) Checking the quench car for proper operation and reporting any abnormalities.

4) Operating the locomotive in a safe, cautious manner and making sure safety equiptment on the loco is operational (motion alarm, whistle, and lights).

5) When calling for an oven, use correct procedures and protocol.

6) Catching and quenching ovens in an even manner assuring proper, sufficient quenching.

7) Checking gates and making sure they are properly closed to eliminate any spillage assuring that the coke will end up on the wharf and not on the quench tracks.

8) When assisting in charging, make sure ovens are charged by the correct procedures assuring safety, efficiency, and eliminating emissions.

9) Operating equiptment and performing job duties in accordance with the standard operating procedures.

10) Following all plant, area, and safety rules.

11) Performing other duties as directed by supervision.

Safety and Area Rules - Quench Locomotive

1) Racal helmets must be worn. Flame retardant clothing, safety shoes are required on the battery and operating the loco.

2) Do not stand on or climb over railings or other parts of the quench car and battery that are intended to be safety restrictions.

3) Use the ladders, walkways, and railing access provided when entering or leaving the quench locomotive.

4) Use the whistle on the locomotive to let others know that the quench car is about to move.

5) Make sure motion alarm is working on the loco. Be aware of other personnel and machinery on the quench tracks when moving the loco.

6) When on the battery top, do not stand on charge hole lids. Be alert for open charge holes and flue caps.

7) Use correct procedures and precautions for calling for, catching, quenching, and putting an oven on the wharf.

8) Bring any safety, mechanical, electrical, or operational concern you may have to the attention of your foreman.

Pusher Operato. Procedures

1) Before the start of the shift, the operator checks with the GF for any changes or additions in battery operating conditions or procedures.

2) Operator copies oven schedule from chalkboard in the schedule room.

3) Operator checks the pusher for travel, motion alarm, brake operation, hydraulic pump operation, extractor controls, extractor operation, lights, and reports any mechanical or electrical abnormality to the GF.

4) Before the scheduled push time, the operator checks to see if the pusher tracks and pusher side bench are clear of people and machinery and proceedes to line up on the oven to be pushed.

5) Operator checks the door number on the door to be pulled to make sure he is on the right oven. He checks the pusher side bench again for personnel passing by and if clear, swings the extractor around to the door. After making sure the extractor hooks are securely under the door and that the latches are free of the frame hooks, the operator pulls the door and swings it around in a slow, cautious manner.

6) Operator checks the condition of the frame, door, knife edges, and gasket material and proceedes with correct methods and procedures to prevent emissions once the door is replaced and charged.

7) Operator knows the oven is ready to push after seeing the green interlock lights on and hearing the backdoor machine operator say, "RACKED IN." After hearing the quench car operator give the command to push the oven, EXAMPLE: "PUSH No. 77," the operator checks the bench once more for people passing by before starting the ram. If clear, the operator replies to the quench car operator, "PUSHING No. 77." He pushes the ram control lever forward and watches the ram head enter the oven frame. After the ram moves the coke mass ahead several feet, he hears from the quench car operator, "GUIDE." After he pushes the coke forward about 8 feet, he hears from the quench car operator, "WAGON" and he then knows that the oven is being pushed into the quench car and caught safely. If the operator did not hear, "GUIDE" or "WAGON" or if the quench car operator had said, "STOP THE PUSH," the operator would have brought the control lever to the neutral position and stopped the ram. After asking about the problem, the operator would either continue with the push or notify the GF if a problem existed, depending on the circumstances.

When the ram head is under the #1 charge hole, the operator records the amperage and the time pushed. The operator continues to hold the ram control lever in a forward position until the ram slows and comes to a complete stop.

8) Operator pulls the ram control lever back bringing the ram out of the oven. At this time he may notice dark walls indicating a heating problem or holes in the walls that need to be patched and notify the GF. While bringing the ram back the operator should be aware of the sound the ram makes as it engages the wishbone support for the collapsible end of the ram. He should bring the ram out of the oven in a cautious manner making sure the ram head passes through the oven frame, passes by the extractor, and comes to a complete stop safely.

9) Operator goes down the stairs, grabs a shovel, and with his back to the wind, stands to the side of the oven and shovels the drag into the oven. He then cleans the sill and the floor of the oven where the door will sit. The operator cleans the frame with a scraper bar then goes back up the stairs to the cab. He cautiously swings the door back around, places it in the frame opening, and sets the latches down. After making sure the latches are secure he lets the squeeze off the door and swings the extractor back around. He lets the charge car operator know the door is secure by saying, "READY ON THE FRONT."

10) Operator moves the pusher 2 ovens to the west and spots the machine so that the leveling bar will safely enter the chuck door opening on the oven to be charged. Upon hearing from the charge car operator the signal, "LEVEL," the operator cautiously opens the chuckdoor with the long chuckdoor opening bar. Once completely open, the operator moves the leveling bar control lever forward so that the smoke sleeve comes out and contacts the chuckdoor frame. At this time, he pushes the lever forward all the way sending the bar into the oven until it stops. He brings the bar back out to a certain spot on the bar (washer welded on) and then sends it back in again. He repeats this process until he hears from the charge car operator, "CLOSE THE CHUCK DOOR." He makes one more complete stroke and brings the bar out. Operator cleans the chuckdoor and frame, removes old gasket, checks coal level, installs new gasket, and closes the chuckdoor with closing bar. Once closed, he notifies the charge car operator, "CHUCKDOOR CLOSED." He records the charging time and moves the pusher to the next oven to be pushed.

Job Responsibilities - Pusher Operator

1) Operating the pusher in a safe and cautious manner.

2) Working cooperatively with other operators to insure safe and efficient operation of the battery.

3) Checking the oven pushing schedule and lining up on the correct oven to be pushed or leveled.

4) Checking the pusher for proper operation, making sure safety equiptment on the pusher is operational (motion alarms, lights, and radio), and reporting any abnormalities to the GF.

5) Making sure ovens are pushed and leveled by the correct procedures assuring safety, efficiency, and eliminating emissions.

6) Using correct procedures and protocol when pushing and leveling ovens to eliminate confusion and accidents.

7) Making sure oven doors and chuckdoors are safely secured.

8) Cleaning and maintaining oven frames, oven doors, chuck doors, and gaskets in order to eliminate emissions.

9) Maintaining the pusher and bench in a clean condition, sweeping after every charge and as necessary.

10) Making sure ovens have been charged correctly by looking through the chuckdoor opening and seeing the oven is filled with coal.

11) Reporting all abnormal operating or equiptment conditions promptly to the foreman.

12) Operating equiptment and performing job duties in accordance with the standard operating procedures.

13) Following all plant, area, and safety rules.

14) Performing other duties as directed by supervision.

Safety and Area Rules - Pusher

1) Racal helmets must be worn. Flame retardant clothing, safety shoes are required on the battery and operating the pusher.

2) Do not stand on or climb over railings or other parts of the pusher and battery that are intended to be safety restrictions.

3) Use the stairs, walkways, and railing access provided when entering or leaving the pusher.

4) Make sure motion alarm is working on the pusher. Be aware of other personnel and machinery on the pusher tracks and bench when moving the pusher.

5) Do not stand near or walk under the ram while it is in motion and stand clear of extractor when it is in motion. Make sure others do the same.

6) Use correct procedures and precautions especially when removing and replacing doors, pushing ovens, and when leveling ovens in order to prevent accidents.

7) Bring any safety, mechanical, electrical, or operational concern you may have to the attention of your foreman.

8) Keep the pusher and bench clean. Bench, stairs, walk ways, and cab should be free of trash, tools, hoses, etc.

Backdoor Machine Operator's Procedures

1) Before the start of the shift, the operator checks with the GF for any changes or additions in battery operating conditions or procedures.

2) Operator copies oven schedule from chalkboard in the schedule room.

3) Operator checks the backdoor machine for travel, motion alarm, brake operation, hydraulic pump operation, extractor controls, extractor operation, lights, and reports any mechanical or electrical abnormality to the general foreman.

4) Before the scheduled push time, the operator checks to see if the backdoor machine tracks and cokeside bench are clear of people and machinery and proceeds to line up on the oven to be pushed.

5) Operator checks the door number on the door to be pulled to make sure he is on the right oven. He then swings the extractor around to the door. After making sure the extractor hooks are securely under the door and that the latches are free of the frame hooks, the operator pulls the door and swings it around in a slow, cautious manner.

6) Operator checks the condition of the frame, door, knife edges, and gasket material and proceeds with correct methods and procedures to prevent emissions once the door is replaced and charged.

7) Operator moves the machine to the west so that the coke guide lines up with the oven to be pushed. He turns the hydraulic pump on and pushes the coke guide control lever forward to engage the coke guide with the oven to be pushed. Once the guide is in the locked position, the operator turns the interlock switch on. The interlock lights should come on in the door machine and the pusher. This indicates to the pusher operator that the oven is ready to push and that both machines are lined up on the same oven. The operator tells the quench car operator that he is, "RACKED IN."

8) The quench car operator calls for the oven and catches it. During the push if the door machine operator notices a problem, he turns the interlock switch off, stopping the push.

9) Once the ram head passes back into the oven, the operator pulls back on the guide control lever and brings the guide out of the oven opening. He moves the machine to the east, far enough out of the way so that he has room to work on the oven just pushed. He shovels the drag back into the oven by standing to the side with his back facing the wind. He cleans the sill and the floor of the oven where the door will sit. He cleans the frame using a scraper bar and checks the condition of the walls and reports any abnormalities to the GF.

10) The operator moves the machine back in front of the empty oven and swings the extractor and door around, places the door in the oven frame and secures the latches. After making sure the latches are secure, he lets the squeeze off the door and swings the extractor back around. He informs the charge car operator his door is secure by saying, "READY ON THE BACK."

11) The operator moves the machine to the next oven scheduled to be pushed. He proceeds to the battery top and follows proper charging procedures and cautions.

12) When the charge car operator lifts #3 boot, the door machine operator slides #3 lid on. Then he raises the jumper pipe with a chainfall while the Charge Car Operator slides the jumper lids on with a lid bar. He sweeps and seals the jumper lids and the #3 lid.

13) Supervision reserves the right to make changes, due to changing conditions, to any procedures in order to eliminate emissions, enhance efficiency, and promote safety.

Job Responsibilities - Backdoor Machine Operator

1) Operating the backdoor machine in a safe and cautious manner.

2) Working cooperatively with other operators to insure safe and efficient operation of the battery.

3) Checking the oven pushing schedule and lining up on the correct oven.

4) Making sure safety equiptment on the machine is operational (motion alarms, lights, interlock lights, and radio), and reporting any abnormalities to the GF.

5) Checking the door machine for proper operation and reporting any machanical or electrical problems to the general foreman.

6) Operating the machine using correct procedures assuring safety, efficiency, and eliminating emissions.

6) Using correct procedures and protocol when the oven is being pushed to eliminate confusion and accidents.

7) Making sure oven doors are safely secured.

8) Cleaning and maintaining oven frames, oven doors, and gaskets in order to eliminate emissions.

9) Maintaining the door machine and bench in a clean condition, sweeping after every push and as necessary.

10) Making sure ovens have been charged using correct procedures assuring safety, efficiency, and eliminating emissions.

11) Reporting all abnormal operating or equiptment conditions promptly to the foreman.

12) Operating equiptment and performing job duties in accordance with the standard operating procedures.

13) Following all plant, area, and safety rules.

14) Performing other duties as directed by supervision.

Safety and Area Rules - Backdoor Machine

1) Racal helmets must be worn. Flame retardant clothing, safety shoes are required on the battery and operating the door machine.

2) Do not stand on or climb over railings or other parts of the door machine and battery that are intended to be safety restrictions.

3) Make sure motion alarm is working on the machine. Be aware of other personnel and machinery on the bench when moving the door machine.

4) Use correct procedures and precautions especially when removing and replacing doors, positioning the coke guide, and while the oven is being pushed.

5) When on the battery top, follow correct charging procedures and precautions. Do not stand on charge hole lids and be alert for open charge holes and flue caps.

6) Bring any safety, mechanical, electrical, or operational concern you may have to the attention of your foreman.

7) Keep the door machine and bench clean. Bench, stairs, and walkways should be free of trash, tools, hoses, etc.

CONCLUSION

ELIMINATE ALL EMISSIONS -

1) Have chuckdoor closed before lifting the boots and moving off the charge hole.

2) Have only one lid off at a time.

3) Seal all leakers on top.

4) Clean door frames.

5) Use new chuckdoor gaskets.

FOLLOW PROCEDURES - Work like you have someone looking over your shoulder because you will have.

Leaks must be stopped before going to the next oven. It's going to take a little longer to push and charge ovens but correct procedures must be followed so that we remain in compliance and we continue to operate. We cannot afford to operate being fined $25,000 per day by the EPA.

COMMUNICATION - We value your input. If you have suggestions we are willing to listen. I have a mailbox at security if you need to contact me. If you have a problem or if something is not working - notify your GF. Change is not always easy but sometimes necessary. We are being forced to change by the Clean Air Act and we are going to do what ever we have to - to continue to operate. Many modifcations and changes have to be made to the way we operate and to the machinery within the next year so try to remain flexible. Try to make this work.

This is not your last meeting. Meetings which will include videos and slide presentations are already in the planning.

WORK SAFELY

START NOW

QUESTIONS?

Presented by Don Dustin of QKS

Tonawanda Coke Corporation Safety Training Employee Sign-In

Topic HazWoper: ~~Awareness level~~ 8-HR. REFRESHER 2010

Supervisor/Trainer Don Dustin

Date 4/10/13

Employee (Print Name)	Employee Signature	Clock #
Robert D Schumacher Jr.	Robert D Schumacher	275
PETER KLEMENCIC	P M Klemenc	0000
Greg Graham	Greg Graham	208
Orin Joyce		628
JOSEPH C. TUCKER	Joseph C. Tucker	187
RYAN GATH		NA
Boris Burch	Boris Burch	214
Reggie Muhammad	Reggie Muhammad	258
G J. BOGACZ	G J Bogacz	

Tonawanda Coke Corporation Safety Training Employee Sign-In

Topic HAZWOPER

Supervisor/Trainer DON DUSTIN

Date 4/17/13

Employee (Print Name)	Employee Signature	Clock #
PETE KLEMENICH	P Klemenich	130
Orin Jose		628
Boris Burch	R R	214
ROBERT KOLVEK JR	Robert Kolvek	135
Greg Graham	Greg Graham	208
Bob Schumacher Jr.	Robert D Schumacher	275
RYAN GATH		
GJ BOGACZ		

Tonawanda Coke Corporation Safety Training Employee Sign-In

Topic Hazwoper Emergency Response

Supervisor/Trainer Don Dustin RHS

Date 7/18/13

Employee (Print Name)	Employee Signature	Clock #
EUGENE DOPIERALA		131
Mark Bertsch		203
DAVE DAHL		194
Michael Mazerka		283
[illegible]		115
DENNIS MOCK		150